

Date: Monday, 9/10/2007 10:03:20 AM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 34473	Part Number	: D3121241
Estimate Number	: 10716	Drawing Number	: D3121 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 9/10/2007	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 9/10/2007
Previous Run	: 31760	Qty:	6
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est Rev:A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
		Comment: Qty.: 0.0546 f(s)/Unit Total : 0.3276 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) Identify as D3121-25 Batch: <i>N/A</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr	<i>N/A Pulled from stock D3121-25 325</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>N/A</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>N/A</i>
5.0	D312123	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing SX B32170 / IX B30520	<i>c2</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 10:03:20 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 34473

Part Number: D3121241

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



X6

ml06/09/10 (P)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

D3121-25 B32259CZ

7.0 QC5 INSPECT WORK TO CURRENT STEP.



cantes

Es 01/09/10 X6

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/8/10 6x Sp

(6)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



1707/09/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

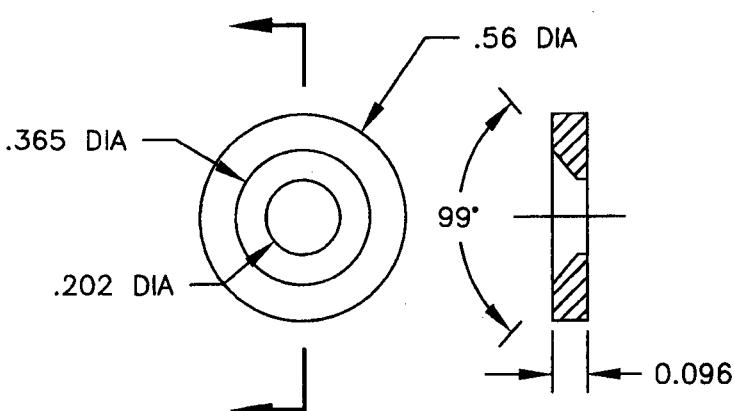
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	6.0	two parts (Boring) Scrap small dent in the inner seal. Loc improper assembly human error	D31212	Scrap and destroy and Replace Boring B4 <u>B32170</u> D32125 CAP B2 <u>B32251</u>	ML 07/09/10	ES 07/09/10	WSM12	WSM12

NOTE: Date & initial all entries

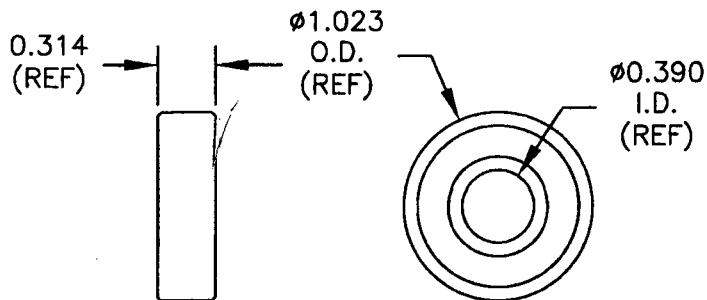
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121
DATE 06.05.17		TITLE BRACKET ASSEMBLY

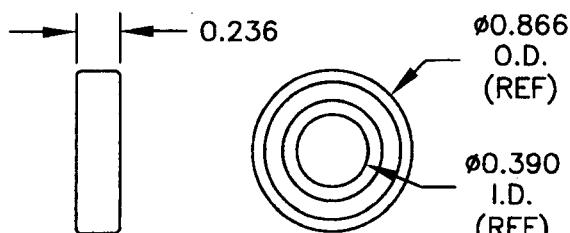
REV. D
SHEET 10 OF 10
1:1

**D3121-17 WASHER (SCALE 2:1)**

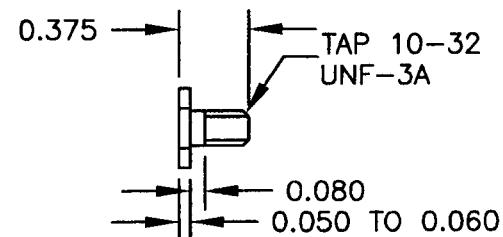
- 1) REPLACES PRÉMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

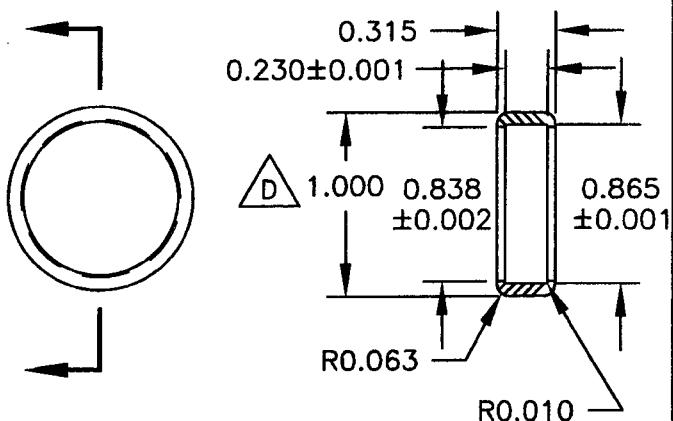
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

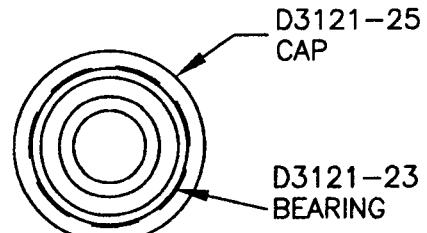
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.06.02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.